

Work Order ID 82576

April-03-12 8:37:41 AM

82576

Page 1

Item ID: D212-664-101TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 03/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D212-664-141	Rev D (DEO)
--------------	-------------

100 0.00

100 MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo 0.00

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AA

DWG REV: D

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110 QC1- Inspect dimensions to dimension sheet 0.00

110 QC

Quality Control

Memo 0.00

12/04/09

1 0

AM.1 12/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82576

April-03-12 8:37:41 AM

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Page 2

Item ID: D212-664-101TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 03/04/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

1-Turn second side as per Folio FA113

2-Blend transition lines only, **do not sand whole tube**:
*Use mill bastard file, brush file repeatedly with file card.
*Do not use sandpaper coarser than 320 grit.

FOLIO REV: 4A

DWG REV: 5

3-Remove sand and plugs

130

130

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

Mori L/KC 12/04/09

C/0

Mori L 12/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82576***82576***

April-03-12 8:37:41 AM

Page 3

Item ID: D212-664-101TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 03/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Quality Control

145

145

Crosstubes

Memo

0.00

Crosstubes

0.00

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

 12-4-9

150

150

HandFXtube

Crosstubes Chemical Conversion

0.00

Hand Finishing Crosstubes

Memo

0.00

 12-4-10 12-4-10  Rm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82576

April-03-12 8:37:41 AM

82576

Page 4

Item ID: D212-664-101TRN

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 03/04/2012 Start Qty: 1.00 ***1***Required Date: 17/04/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

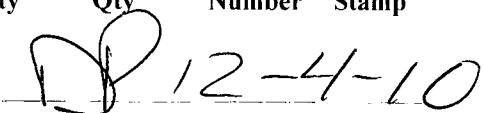
160

QC

Quality Control

QC3- Inspect Part Finish

0.00


12-4-10

170

170

Packaging

Packaging

0.00


MM, L

Packaging

Identify and Stock in kanban rack
Location: b/6

Memo

0.00

180

180

QC

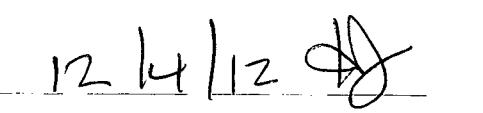
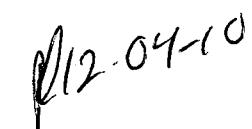
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00


12-4-12 
12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-03-12 8:37:44 AM

Page 1

Work Order ID: 82576

82576
D212-664-101TRN

Parent Item: D212-664-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128		Manufactured	No			120	Each	33.0000	1	1			**

D6005-128

Crosstube Material

Location
LG
69796

Loc Qty
33
33

Loc Code

 man
 ke 12/4/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82576
Description: Crosstube Assembly (205/212/412 High Fwd)		Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: D			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	200	/		
	R0.063	+/-0.010	.010	/	RG	
	2.740	+0.005/-0.000	2.741	/	VERN	CNC 08
	5.097	+/-0.030	5.097	/		
	2.304	+0.005/-0.000	2.308	/		
	2.340	+0.005/-0.000	2.342	/		
	2.398	+0.005/-0.000	2.403	/		
	2.448	+0.005/-0.000	2.452	/		
	2.498	+0.005/-0.000	2.502	/		
	2.549	+0.005/-0.000	2.554	/		
	2.599	+0.005/-0.000	2.603	/		
	2.671	+0.005/-0.000	2.673	/		
	2.701	+0.005/-0.000	2.703	/		
SIDE B	0.200	+/-0.010	200	/		
	R0.063	+/-0.010	.010	/	RG	
	2.740	+0.005/-0.000	2.741	/	VERN	CNC 08
	5.097	+/-0.030	5.097	/		
	2.304	+0.005/-0.000	2.309	/		
	2.340	+0.005/-0.000	2.345	/		
	2.398	+0.005/-0.000	2.403	/		
	2.448	+0.005/-0.000	2.453	/		
	2.498	+0.005/-0.000	2.502	/		
	2.549	+0.005/-0.000	2.554	/		
	2.599	+0.005/-0.000	2.602	/		
	2.671	+0.005/-0.000	2.673	/		
	2.701	+0.005/-0.000	2.703	/		
	126.514	+/-0.020	126.514	/	MML 2	MML 2

Measured by:	KJM, L/KC	Audited by:	D	Prototype Approval:	N/A
Date:	12/01/01	Date:	12-4-9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	
D	10.02.02	Dimension 126.514 was 126.51	KJ	M



Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2	X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82576 MLJ

12/04/03

REMOVED FROM UNDER REVIEW PER
UNDER REVIEW ECRN#11-614
OF 11/01/03
FOR MRY SEALING SUPPORT
21/07/06

DEO ATTACHED

RELEASED
2009-10-29
M

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
---	--	----	----------

C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
---	--	----	----------

B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
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A	NEW ISSUE	PH	00.12.12
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REV.	DESCRIPTION	BY	DATE
------	-------------	----	------

DESIGN	R4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PP	DRAWING NO.	REV. D
MFG. APPR.	DA	D212-664-141	SHEET 1 OF 4
APPROVED	MO	TITLE	SCALE
DE APPR.	MM	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE, COPIED, OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2

D

1

6

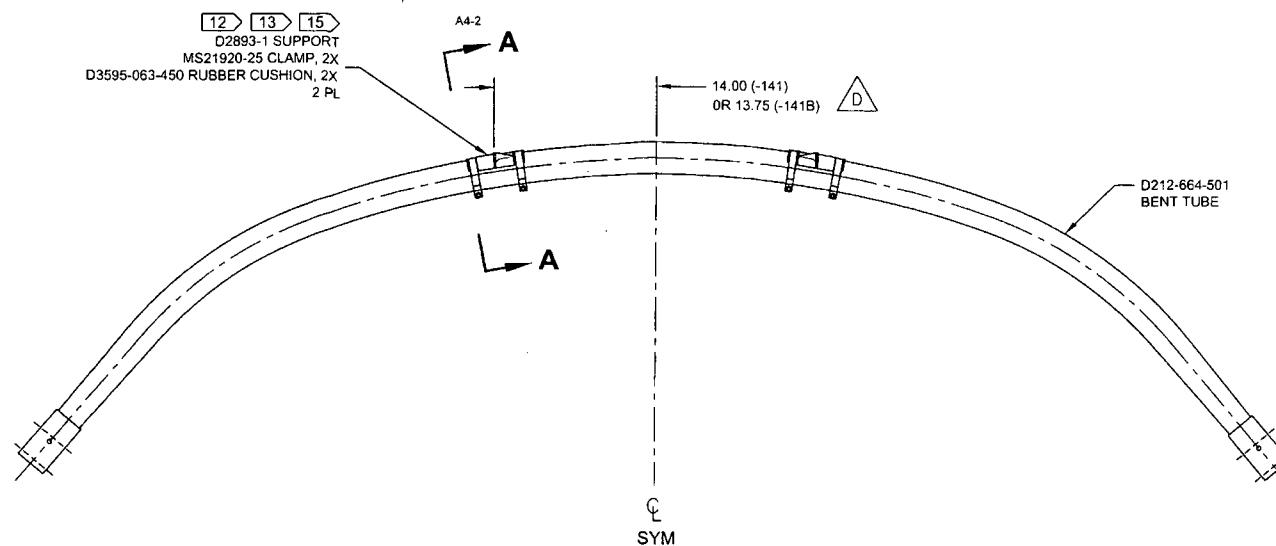
1

8

1

A

1



82578

8.07.20
~~UNDER REVIEW~~
~~Q1 11.9.13~~

DEO ATTACHED

RELEASED
2009-10-29

D2893-1 SUPPORT, REF

APPLY MAGNOBOND BETWEEN D2893-1 AND CROSSTUBE

D3595-063-450 RUBBER CUSHION UNDER CLAMP, REF

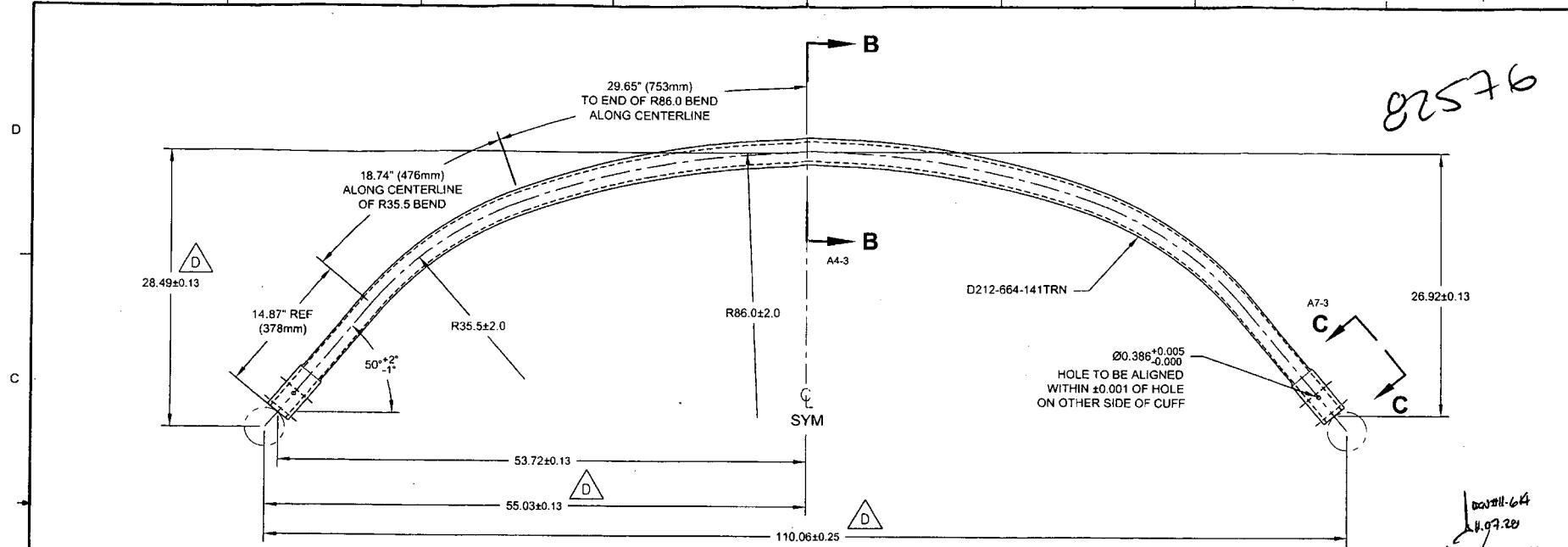
MS21920-25 CLAMP, REF

SECTION A-A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. D
MFG. APPR.	DL	D212-664-141	SHEET 2 OF 4
APPROVED	100	TITLE	SCALE
DE APPR.	100	XTUBE ASSY (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

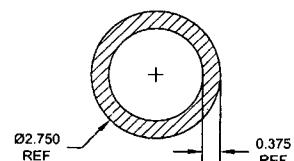
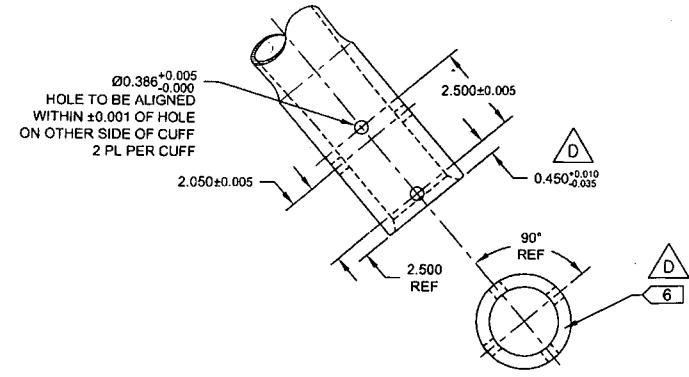
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



D212-664-501
BENDING AND DRILLING DETAIL 10 > D

UNDER REVIEW
01/09/03



VIEW C-C: CUFF DETAIL C2-3
SCALE 3X

SECTION B-B C4-3
SCALE 4X

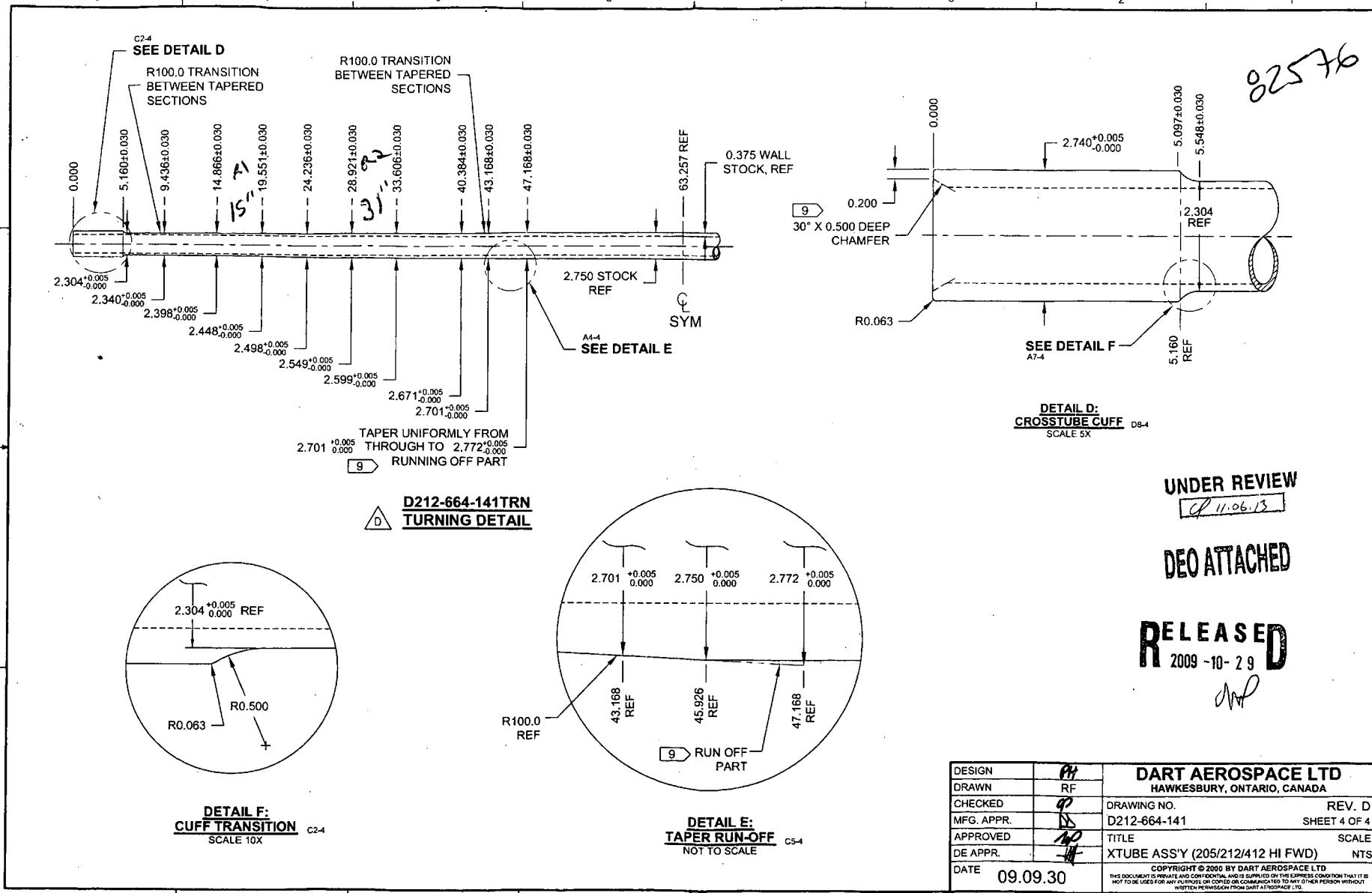
DESIGN	R	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	Q	DRAWING NO.
MFG. APPR.	DA	D212-664-141
APPROVED	AD	REV. D
DE APPR.	SH	SHEET 3 OF 4
DATE	09.09.30	SCALE
		NTS

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DEO ATTACHED

RELEASED
2009-10-29
AD

8 7 6 5 4 3 2 1



82576

DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN DATE 11.04.07	CHECKED DATE 11.04.11	OP	MFG. APPR. R	DATE 11.04.12	APPROVED MP	DE APPR. HN	DATE 11.04.12

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

RELEASED
2011-04-18
HN

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
 PAINT OUTSIDE PER DART QSI 005 4.2
 REMOVE MASKING AND APPLY CLEAR COAT

UNDER REVIEW
 11/06/13
 D212-664
 11.07.28
 HN

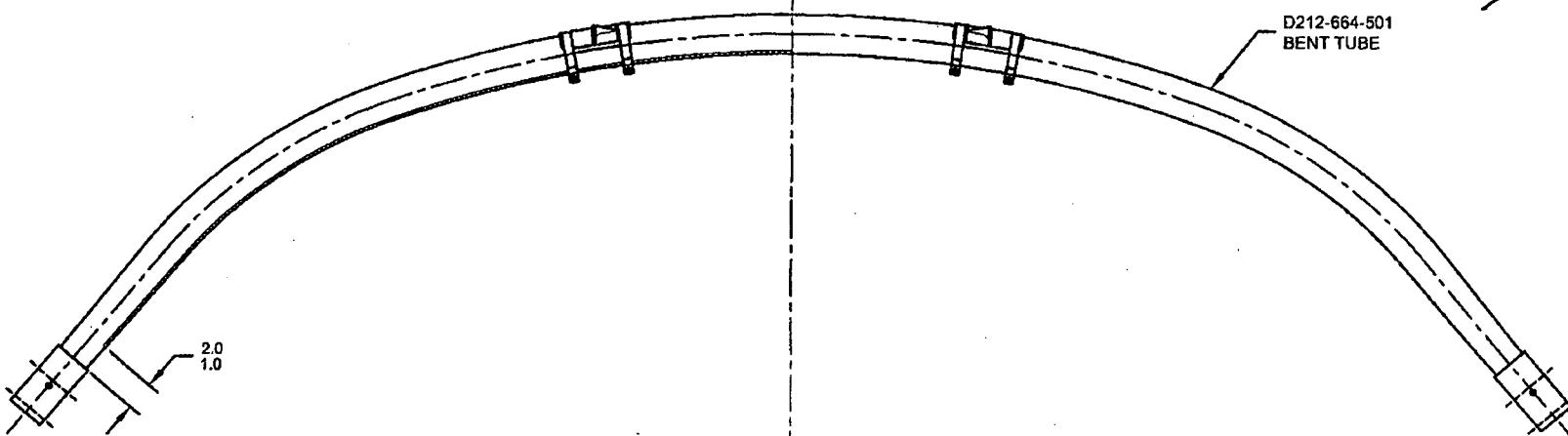
WAS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2

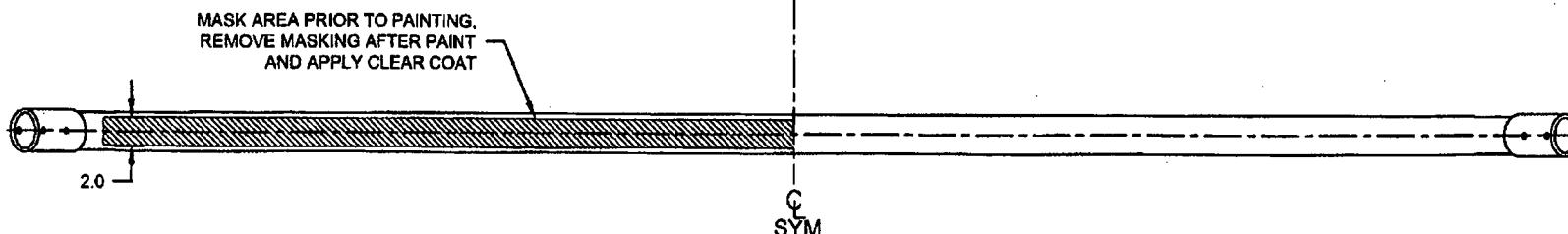
82576

DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN DATE 11.04.07	CHECKED DATE 11.04.11	APPROVED DATE 11.04.12	MFG. APPR. DATE 11.04.12	APPROVED DATE 11.04.12	DE APPR. DATE 11.04.12		

UNDER REVIEW

IS:WAS:

D212-664-141/-141B
ASSEMBLY DETAIL



825 76

DRAWING NO. D212-664-141	TITLE CROSSTUBE ASS'Y (205 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>DP</i>	CHECKED <i>A>S</i>		MFG. APPR. <i>DP</i>	APPROVED <i>MD</i>	DE APPR. <i>DP</i>	
DATE 11.07.15	DATE 11.07.20		DATE 11.07.21	DATE 11/07/21	DATE 11.07.21	

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1, SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

THE LK 2011-07-28
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ULTRA SONIC MEASURMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A		.206	.303		
		.216	.288		
		.217	.299		
		.207	.306		
B		.206		.221	.306
				.219	.300
				.211	.292
				.200	.294
		Part number	82576		
		Batch number	212-C64-101		
		Measured By	m.m.L		